

Work Order ID 51118

August 4, 2009 11:04:49 AM



Page 1

Item ID: D3725-1

Accept



Setup Start



Revision ID: A

Stop



Item Name: Hoop

Start Date: 8/07/09

Start Qty: 10.00



Cust Item ID:

Required Date: 8/21/09

Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan: YMF

Date: 09-08-09 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3725

Rev A.

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3725 IDwg Rev: A Prog Rev: A

13 9-11-23

15

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

13 9-11-23

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

27809/11/30

278

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

I- Make chamfer by hand as per dwg D3725-02- Deburr

=> m-d 09/12/02

15X

140

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

=> 809/12/02

815

150

0.00



Identify as per dwg & Stock Location:

Steve

Packaging

Memo

0.00

Packaging

9/12/02 15X Sp

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Customer:

Reference:

Run Start



Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/12/03

09-12-3
(15)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

August 4, 2009 11:04:48 AM

Page 1

Work Order ID: 51118

Parent Item: D3725-1RevA

Parent Item Name: Hoop

Comments:

Start Date: 8/07/09

Required Date: 8/21/09

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304B0.625X3.000		Purchased	No			100	f	13.1000	4.3863	6.1407		



304 BAR .625 X 3.00

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

13.1

112320

13.1

107979

$$112320 \times 12 = 5.2635$$

$$107979 \times 3 = 8772$$

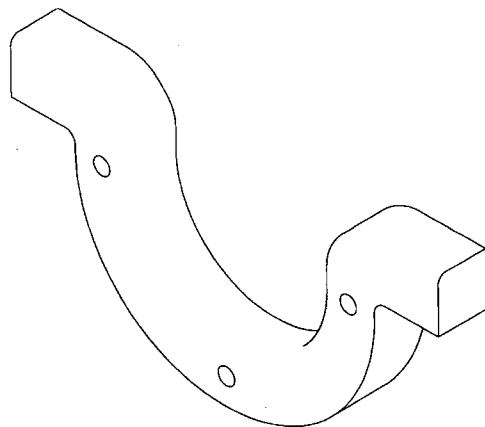
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3725-1 HOOP

#51118
mf
09-08-04

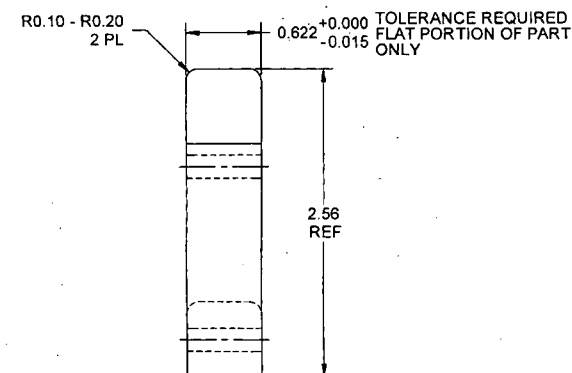
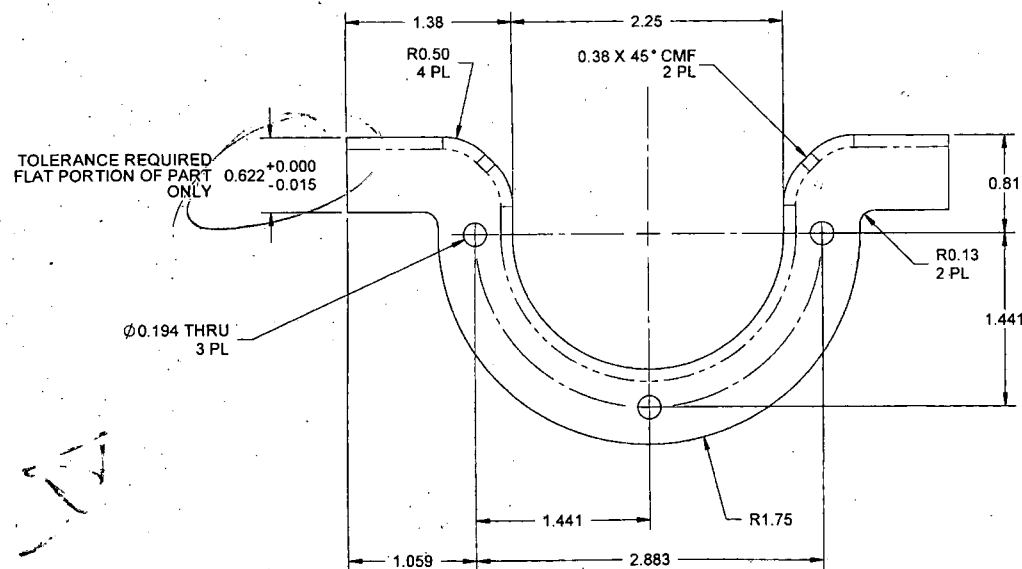
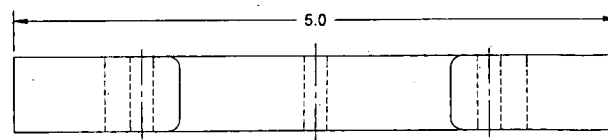
RELEASED
18 08-02-25

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL BAR
(REF. DART SPEC M304B)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.80 lbs

A	INITIAL RELEASE	AJS	08.01.28
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	MF	DRAWING NO.	REV. A
MFG. APPR.	MF	D3725	SHEET 1 OF 2
APPROVED	MF	TITLE	SCALE
DE APPR.	MF	HOOP	NTS
DATE	08.01.28	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

#51118
MF
09-08-04



D3725-1 HOOP

RELEASED
080225

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	LE	HAWKESBURY, ONTARIO, CANADA	
CHECKED	LE	DRAWING NO. D3725	REV. A
MFG. APPR.	LE	SHEET 2 OF 2	
APPROVED	LE	TITLE HOOP	SCALE
DE APPR.	LE	NTS	
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